

Work Order ID 50966

July 28, 2009 11:43:41 AM



Page 1

Item ID: D3011-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Rappel

Start Date: 31/07/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 04/08/2009 Req'd Qty: 10.00

Customer:

Reference:

09-07-28

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3011	Rev B

100



BAND SAW

Bandsaw

Memo

Jeaspa Bandsaw

Cut Blanks: 26.625"

0.00

0.00

M.A 09/07/28

10

0



110



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

HAAS CNC vertical machine #1

Machine as per folio FA129

Folio Rev: B

Dwg Rev: B

0.00

0.00

SS 09/07/30 / M.A 09/08/01

10

2



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3011-1 PAR #: _____ Fault Category: Prod eng coordination NCR: Yes No DQA: [Signature] Date: 05-09-09
Scrap / scrap QA: N/C Closed: [Signature] Date: 05-09-09

NCR: <u>50966</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/07/30	110	One part Have Rougher mark on it. R.C. During machining the part lift from the vises	<u>[Signature]</u>	Replace B to <u>50360</u> - scrap: destroy. - See below ↓	<u>SS</u> 09/07/30	J.F. 04/08/04	<u>[Signature]</u>	<u>[Signature]</u>
		causing by new Routine on rougher tool feed too fast. Program fixed. # Process / program error	<u>[Signature]</u>	<u>[Signature]</u>	<u>[Signature]</u>		<u>[Signature]</u>	<u>[Signature]</u>
		One part the dimension of 1.250" ±.030 was too small - .010 R.C. Programming error.	<u>[Signature]</u>	- scrap & destroy. & replace. - update the program. - attach revision.	<u>SS</u> 09/07/30	J.F. 04/08/04	<u>[Signature]</u>	<u>[Signature]</u>

NOTE: Date & initial all entries

1913

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

M.A 09/08/01

10 0

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

and 09/08/02

10 0

131

0.00



Outsource2

Memo

0.00

Outsource process - NDT

P10: 10/69
LPI AS PER ASTM 1417 LEVEL 2 AS PER DWG d3011

CL 09/08/05 10

rec'd + inspect + attal report

CL 09/08/05

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Cust Item ID:

Required Date: 04/08/2009 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
132 	QC5- Inspect part completeness to step on W/O	0.00				<i>[Signature]</i>	09 08 05		(10)
QC Quality Control	Memo	0.00				<i>CA</i>	07/08/05		<i>[Signature]</i>
140 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish Hand Finishing	Memo	0.00							<i>[Signature]</i>
150 	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat Powder Coating	Memo START TIME: 11:40 AM OVEN TEMPERATURE: 320°C FINISH TIME: 12:10 PM	0.00							
									1112148 09-08-05 (10) <i>[Signature]</i>

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	bf 09-08-5.			(10)			
170 Packaging Packaging	Identify as per dwg & Stock Location: <u>GA</u> Memo	0.00 0.00				09/08/20		(10)	
180 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00	09/08/25						

mf
09-09-01

Picklist Print

Page 1

July 28, 2009 11:43:41 AM

Work Order ID: 50966



Parent Item: D3011-1RevB



Parent Item Name: Rappel

Start Date: 31/07/2009

Required Date: 04/08/2009

Start Qty: 10.00

Required Qty: 10.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6202RevA		Manufactured	No			110	f	14.0000	10.0000			
I-Beam Extrusion												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

14

50040

14

50630

125'

M.A 09/07/28

22.6666

8 7 6 5 4 3 2 1

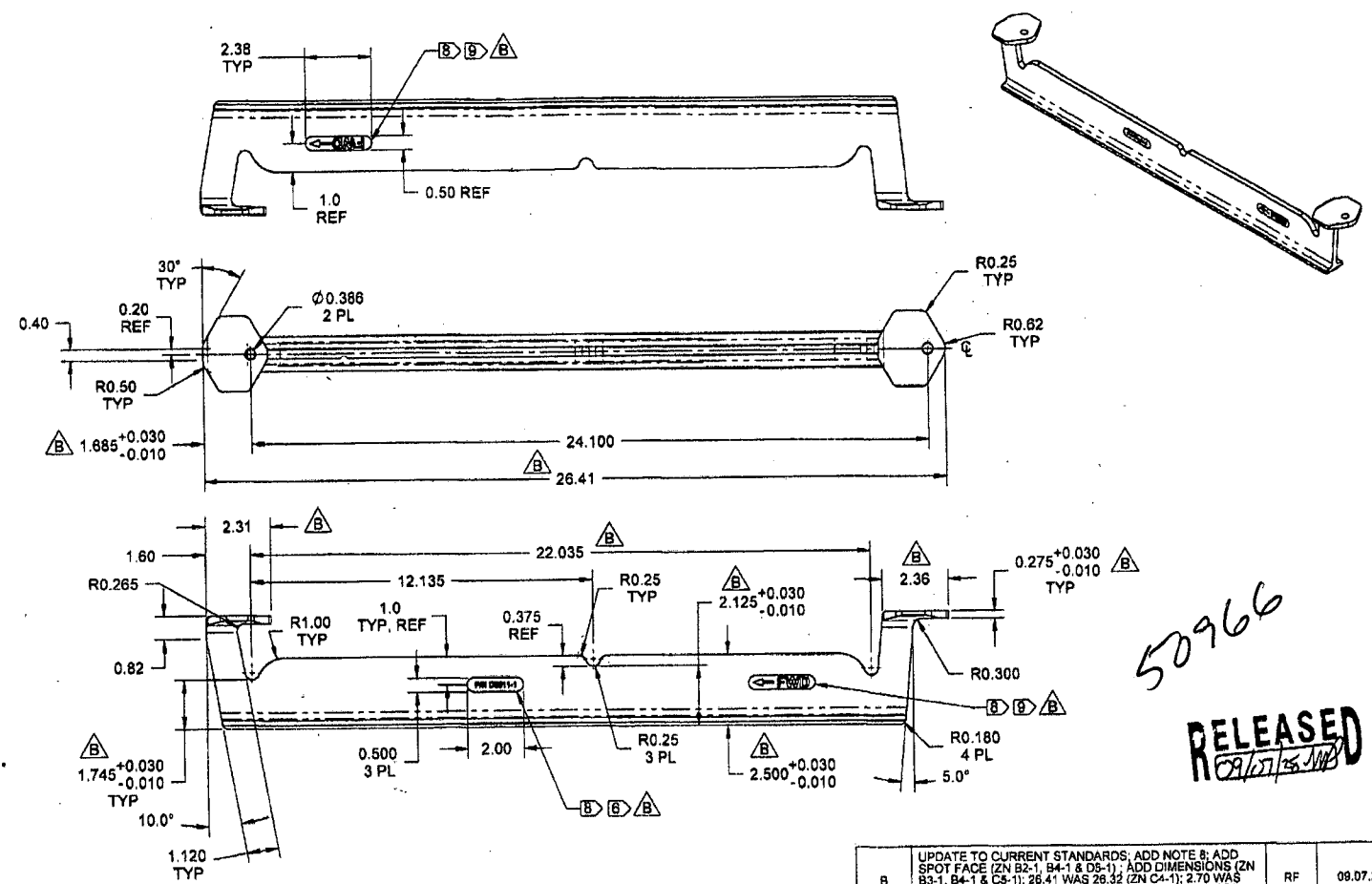
B

A

NOTES:

- 1) MATERIAL: MANUFACTURE FROM D8202-027 EXTRUSION
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN (NEAR SIDE ONLY) TO MAX
DEPTH OF 0.015 IN 0.19 HIGH LETTERS WITH A MIN RADIUS TOOL OF 0.015
- 7) WEIGHT: 3.00 lbs
- 8) SPOT FACE MAX DEPTH OF 0.010 PRIOR TO MARKING
- 9) ENGRAVE "FWD" IN THIS AREA AS SHOWN TO MAX DEPTH OF 0.015 IN
0.38 HIGH LETTERS WITH MIN TOOL RADIUS OF 0.015
- 10) LPI PER ASTM 1417 LEVEL 2

D3011-1 RAPPEL SLIDE BAR



50966

RELEASED
09/27/24

B	UPDATE TO CURRENT STANDARDS; ADD NOTE 8; ADD SPOT FACE (ZN B2-1, B4-1 & D5-1); ADD DIMENSIONS (ZN B3-1, B4-1 & C5-1); 26.41 WAS 26.32 (ZN B7-1); ADD (+0.030/-0.010) TOLERANCES; ADD LPI (ZN A8-1)		RF	09.07.24
	NEW ISSUE		CP	01.03.29
REV.	DESCRIPTION		BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF			
CHECKED	B	DRAWING NO. D3011		REV. B
MFG. APPR.	21	SHEET 1 OF 1		
APPROVED	12	TITLE		SCALE
DE APPR.	12	RAPPEL SLIDE BAR		NTS
DATE	09.07.24		COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1



LIQUID PENETRANT TEST REPORT

P- 14944.

CLIENT	<u>DART AEROSPACE</u>	DATE	<u>AUG 4-2009</u>	PAGE	<u>1</u> OF <u>1</u>
ATTENTION	<u>LINDA / CHANTEL</u>	ACUREN JOB No.	<u>188-09-001480</u>	TIME	AM <input checked="" type="checkbox"/> PM <input type="checkbox"/>
ADDRESS	<u>1270 ABERDEEN ST</u>	PO/NO No.	<u>10169</u>		
	<u>HAWKESBURY ON.</u>	WORK LOCATION	<u>HAWKESBURY</u>		
	<u>KGH 1K7</u>	ACCEPTANCE STD.	<u>ASTM 1417</u>	REV./DATE	<u>2007</u>
PROJECT	<u>F.P.I. ON MACHINED PARTS AND CROSS TUBES</u>				
ITEM(S) EXAMINED					

JOB DESCRIPTION	PROCEDURE No. <u>LT0002</u> REV./DATE	TECHNIQUE No. <u>LT-1417</u> REV./DATE
PART No.	MATERIAL <u>S.S. / ALUMINUM</u> THICKNESS	
SCOPE	<u>WET FLUORESCENT LIQUID PENETRANT INSPECTION</u> <u>CARRIED OUT 100% EXTERNAL</u>	

TEST DETAILS	
METHOD	<input checked="" type="checkbox"/> FLUORESCENT <input type="checkbox"/> VISIBLE
FAMILY BRAND	<u>MAGNAFLUX</u>
PENETRANT	<u>2L 67</u> MINIMUM DWELL TIME <u>45</u> MIN.
PENETRANT REMOVER	<u>H2O</u> MINIMUM DRY TIME <u>>10</u> MIN.
DEVELOPER	<u>SKD 52</u> MINIMUM DWELL TIME <u>10</u> MIN.
DEVELOPER TYPE	<input checked="" type="checkbox"/> NON AQUEOUS <input type="checkbox"/> AQUEOUS <input type="checkbox"/> DRY
	CAL DUE DATE <u>DEC. 8-2009</u>

TEST SURFACE	
SURFACE CONDITION	<input type="checkbox"/> AS GROUND <input checked="" type="checkbox"/> AS WELDED <input type="checkbox"/> MACHINED <input type="checkbox"/> SHOT BLASTED <input checked="" type="checkbox"/> CLEAN BARE METAL
SURFACE TEMPERATURE	<input type="checkbox"/> < -4°C/ 20°F <input type="checkbox"/> -4°C/ 20°F TO 10°C/50°F <input type="checkbox"/> 10°C/50°F TO 52°C/125°F <input type="checkbox"/> > 52°C/125°F

RESULTS- <input type="checkbox"/> METRIC <input type="checkbox"/> IMPERIAL	
W.O. <u>50388</u> <u>40 MACHINED PARTS</u>	ACCEPT <input checked="" type="checkbox"/> REJECT
W.O. <u>50965</u> <u>10 PCS</u>	
W.O. <u>50966</u> <u>10 PCS</u>	
W.O. - <u>50796</u> - <u>1 PC</u>	
W.O. - <u>50798</u> - <u>1 PC</u>	
W.O. - <u>50797</u> - <u>1 PC</u>	
W.O. - <u>50667</u> - <u>1 PC</u>	
ALL ITEMS INSPECTED WERE FOUND ACCEPTABLE <u>090805</u>	

Scope of Services
The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES	
CLIENT REPRESENTATIVE	<u>MATTHEW MURDOCH</u>
TECHNICIAN (SIGNATURE):	<u>Mike Johnston</u>
NAME (PRINT):	<u>Mike Johnston</u>
CGSB LEVEL	<u>II</u> SNT LEVEL
CGSB REG. No.	<u>60666</u>
DTR #	<u>E-20066</u>
REPORT REVIEWED BY:	
NAME	INITIALS